

Work Order ID 74099



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Wednesday, September 21, 2011 1:27:16 PM

Item ID: D4032-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Short Basket Assembly (350)

Start Date: 9/28/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/30/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date: 11/09/21

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4032

D

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/9/30

110

Assemble as per dwg

0.00



HandFinish

Memo

0.00

Hand Finishing

****Mask label plate to size of D4086 label, use scotchbrite red pad to lightly sand area for label, apply label ****

1 11/10/03

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11/10/03

11/10/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74099

Wednesday, September 21, 2011 1:27:16 PM



Page 2

Item ID: D4032-041	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Short Basket Assembly (350)					
Start Date: 9/28/2011	Start Qty: 1.00		Cust Item ID:		
Required Date: 9/30/2011	Req'd Qty: 1.00		Customer:		
Reference:					

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Identify as per dwg & Stock Location: <u>wlo</u>	0.00							
Packaging	Memo	0.00							
Packaging									
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

PP 74099

11/10/11 SF

11/10/11

MF 11-10-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Wednesday, September 21, 2011 1:27:21 PM

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Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.12.02 verified by:EC IPP Rev:B as per PA3 DD 10.03.10 verified by:EC IPP Rev:C as per RevA DD 10.03.23 verified by:EC IPP Rev:D as per dwg revC DD 10.04.20 verified by:EC IPP Rev:E as per dwg revD DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4086-232  Placard, Max Load		Manufactured	No			100	Each	4.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST122		4							
					72052	4							
D2530  Handle Weldment		Manufactured	No			100	Each	8.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST506		7							
					72166	7							
				ST508		1							
					69318	1							
D2535  Spring		Manufactured	No			100	Each	79.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST504		79							
					71117	79							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

Wednesday, September 21, 2011 1:27:21 PM

Work Order ID: 74099

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 9/28/2011

Required Date: 9/30/2011

Start Qty: 1.00

Required Qty: 1.00

D2537

Manufactured No

100 Each

53.0000

2 2



Bushing

Location

Loc Qty

Loc Code

ST504

53

71853

23

73344

30

D3917-3

Manufactured No

100 Each

53.0000

6



Washer

Location

Loc Qty

Loc Code

ST092

53

72142

7

73332

46

D3953-3

Manufactured No

100 Each

12.0000

2



Gas Spring Stud, Lid

Location

Loc Qty

Loc Code

ST096

12

71875

12

D3953-7

Manufactured No

100 Each

9.0000

2



Spring Spacer

Location

Loc Qty

Loc Code

ST096

9

65053

4

71885

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 74099

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 9/28/2011

Required Date: 9/30/2011

Start Qty: 1.00

Required Qty: 1.00

D3953-9

 Gas Spring Washer

Manufactured No

100 Each

8.0000

2

2



B74169

Location

Loc Qty

Loc Code

ST096

8

69025

4

71869

4

D3953-17

 Gas Spring Spacer

Manufactured No

100 Each

30.0000

2



Location

Loc Qty

Loc Code

ST096

30

73474

30

D3953-19

 Gas Spring Bracket

Manufactured No

100 Each

14.0000

1



Location

Loc Qty

Loc Code

ST096

14

59213

1

68462

3

73551

10

D3953-21

 Gas Spring Bracket

Manufactured No

100 Each

20.0000

1



11/9/30

Location

Loc Qty

Loc Code

ST096

20

68463

3

73557

17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 74099

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 9/28/2011

Required Date: 9/30/2011

Start Qty: 1.00

Required Qty: 1.00

D3969-3

 Spring (Basket Lid)

Manufactured No

100 Each

34.0000

1

1



Location

Loc Qty

Loc Code

ST272

34

64285

1

68925

3

73515

30

D4017-041

 Short Basket Base Assembly (350)

Manufactured No

100 Each

0.0000

1

1



B74100

D4018-041

 Short Basket Lid Assembly (350)

Manufactured No

100 Each

0.0000

1

1



B74101

AN3-14A

 Bolt

Purchased No

100 Each

76.0000

4

4



Location

Loc Qty

Loc Code

ST352

76

117872

76

4

AN3-16A

 Bolt

Purchased No

100 Each

167.0000

2

2



11/9/30

Location

Loc Qty

Loc Code

ST352

167

117441

67

118628

100

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Wednesday, September 21, 2011 1:27:23 PM

Work Order ID: 74099

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 9/28/2011

Required Date: 9/30/2011

Start Qty: 1.00

Required Qty: 1.00

AN4-12 Purchased No 100 Each 72.0000 3



Bolt



3

Location Loc Qty Loc Code

ST357 72
117514 22
118626 50

3

AN5-17A Purchased No 100 Each 98.0000 4



Bolt



4

Location Loc Qty Loc Code

ST337 4
118422 4
ST339 94
117872 44
118706 50

4

AN310-4 Purchased No 100 Each 21.0000 3



NUT



3

Location Loc Qty Loc Code

ST324 21
118112 21

3

AN310C4 Purchased No 100 Each 47.0000 2



Nut



2
11/9/30

Location Loc Qty Loc Code

ST324 47
116741 4
117395 13
118090 10
118626 20

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

Wednesday, September 21, 2011 1:27:23 PM

Work Order ID: 74099

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 9/28/2011

Required Date: 9/30/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L3 Purchased No 100 Each 2,592.000 6



Nut



6
sf

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST300	2592	
117441	24	
117601	363	
117885	205	6
118451	1000	
118927	1000	

MS21042L5 Purchased No 100 Each 1,287.000 4



Nut



4
sf

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST300	1287	
116105	5	
116548	53	
117441	343	4
117611	90	
118179	496	
118910	300	

MS24665-151 Purchased No 100 Each 414.0000 3



Cotter Pin



3
sf 11/9/30

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST309	414	
17566	414	

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Wednesday, September 21, 2011 1:27:23 PM

Work Order ID: 74099

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 9/28/2011

Required Date: 9/30/2011

Start Qty: 1.00

Required Qty: 1.00

MS24665-300

Purchased

No

100

Each

248.0000

2



Cotter Pin

Location

Loc Qty

Loc Code

GA

200

118234

200

ST309

48

116823

48

NAS1149F0432P

Purchased

No

100

Each

218.0000

6



Washer

Location

Loc Qty

Loc Code

ST275

218

117291

8

118612

10

118840

200

NAS1149C0432R

Purchased

No

100

Each

4,234.000

2



Washer

Location

Loc Qty

Loc Code

ST297

4234

117291

4234

NAS1149F0332P

Purchased

No

100

Each

162.0000

8



WASHER

Location

Loc Qty

Loc Code

ST275

162

117735

63

118354

96

17317

3

Wednesday, September 21, 2011 1:27:23 PM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Wednesday, September 21, 2011 1:27:23 PM

Page 8

Work Order ID: 74099

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 9/28/2011

Required Date: 9/30/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0563P

Purchased

No

100

Each

180.0000

4



sf 11/9/30/8

Washer

Location

Loc Qty

Loc Code

ST297

180

117735

180

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

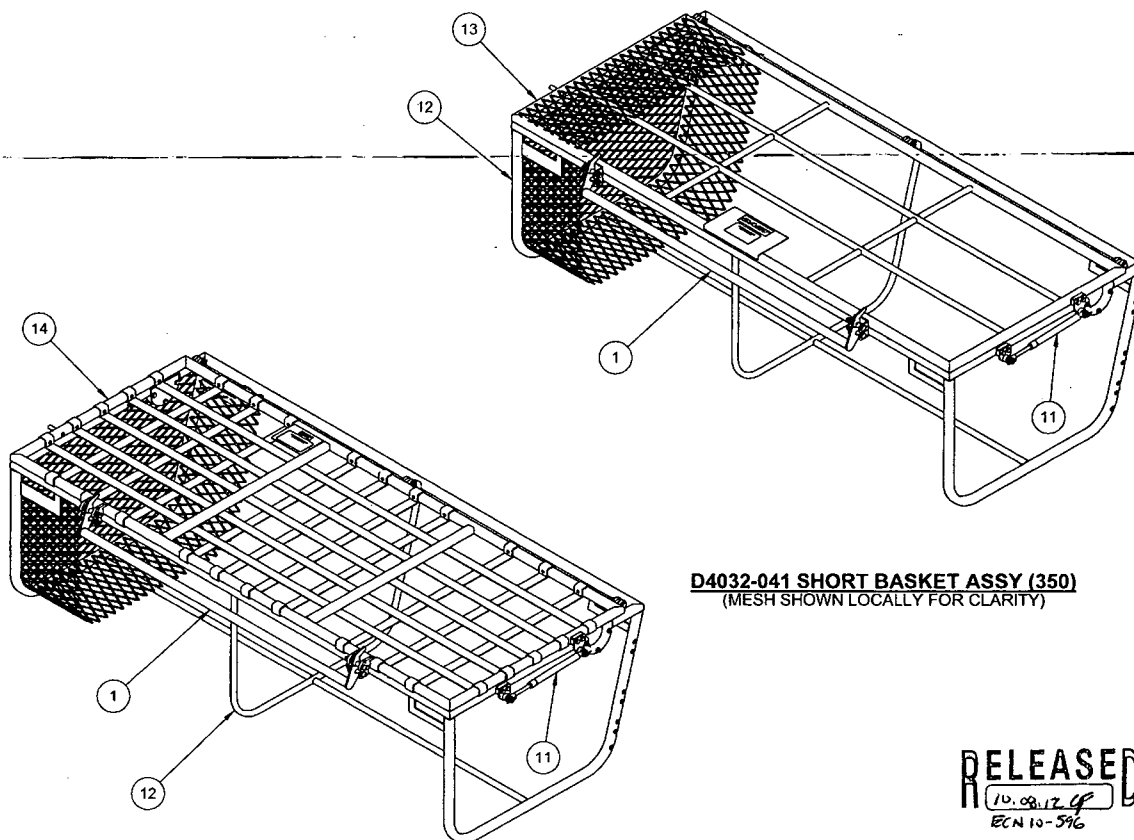
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	-041 QTY.	-043 QTY.	P/N	DESCRIPTION
	X		D4032-041	SHORT BASKET ASSY (350)
		X	D4032-043	SHORT BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	2	2	D2537	BUSHING
4	6	6	D3917-3	WASHER
5	2	2	D3953-3	GAS SPRING STUD, LID
6	2	2	D3953-7	GAS SPRING SPACER
7	2	2	D3953-9	GAS SPRING WASHER
8	2	2	D3953-17	GAS SPRING SPACER
9	1	1	D3953-19	GAS SPRING BRACKET
10	1	1	D3953-21	GAS SPRING BRACKET
11	1	1	D3969-3	SPRING
12	1	1	D4017-041	SHORT BASKET BASE ASSY (350)
13	1	1	D4018-041	SHORT BASKET LID ASSY (350)
14		1	D4019-041	LIGHT LID SHORT BASKET ASSY
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	2	2	NAS1149C0432R	WASHER
29	8	8	NAS1149F0332P	WASHER
30	4	4	NAS1149F0563P	WASHER



D4032-041 SHORT BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

D4032-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: N/A
 7) WEIGHT: -041: 56 lbs APPROX
 -043: 45 lbs APPROX

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER

NO. 74089

D	QTY FOR ITEMS #28, #29 & #30 UNDER -043 WERE MISSING (B8-1). QTY FOR ITEM #3 WAS 4 (D6-1). ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3).	MB	10.07.23
C	AN5-21A BOLT WAS AN5-19A BOLT: BOM & (D3-3)	JPH	10.04.06
B	ITEM 15 D4086-232 & 16 D4086-243 REMOVED; ITEM RENUMBERED AS REQD. PLACARDS REMOVED (C6-2); TOP VIEW DETAIL REMOVED (C2-2)	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.08
REV.	DESCRIPTION	BY	DATE
DESIGN	1.15		
DRAWN	1.15		
CHECKED	1.15		
MFG. APPR.	1.15		
APPROVED	1.15		
DE APPR.	1.15		
DATE	10.07.23		

DART AEROSPACE LTD
 HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4032** REV. D
 SHEET 1 OF 3
 TITLE **SHORT BASKET ASSY (350)** SCALE
 NTS

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RELEASED
 10.08.17
 ECN 10-596

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

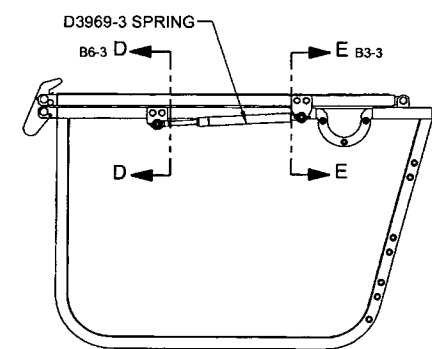
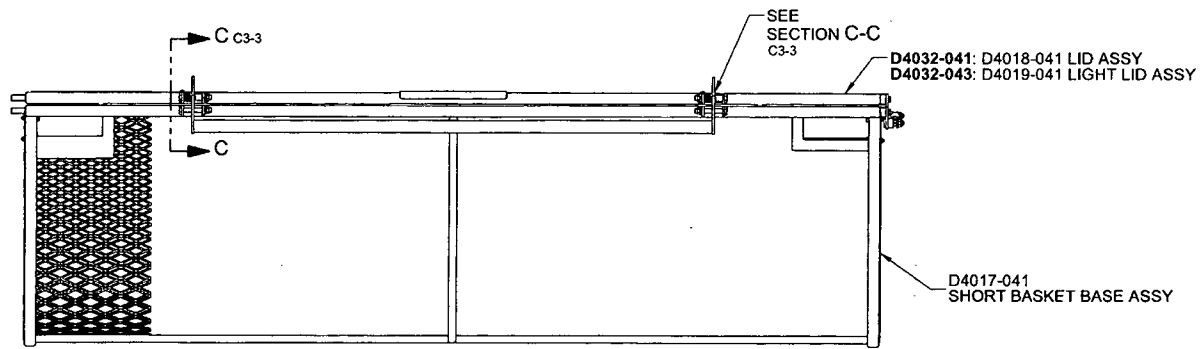
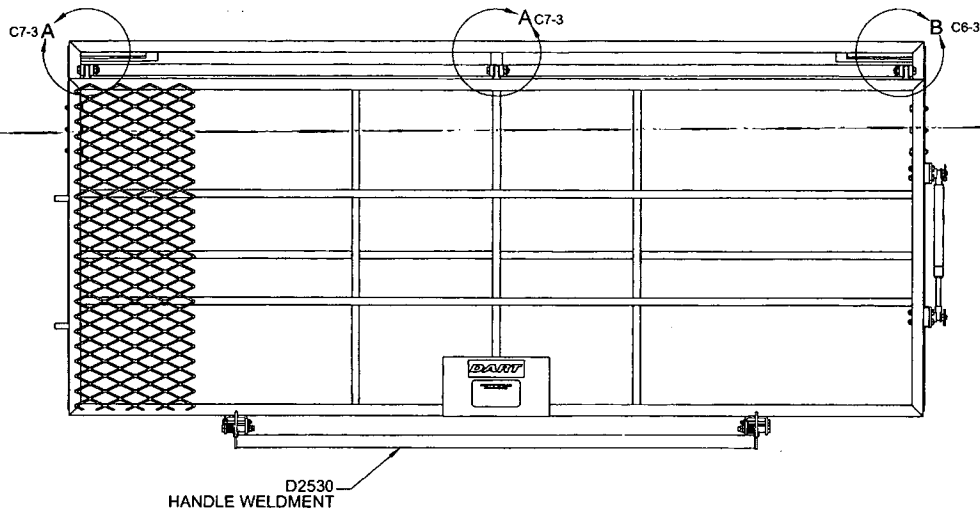
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D4032-041 SHORT BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)
D4032-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.23

14029

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	h	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JFS	DRAWING NO. D4032	REV. D
MFG. APPR.	JFS	SHEET 2 OF 3	
APPROVED	W	TITLE	SCALE
DE APPR.	W	SHORT BASKET ASSY (350) - NTS	
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

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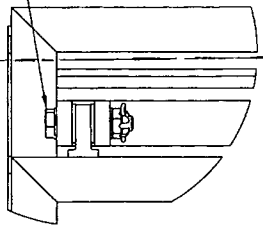
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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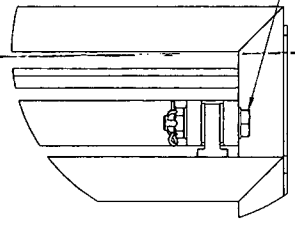
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AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



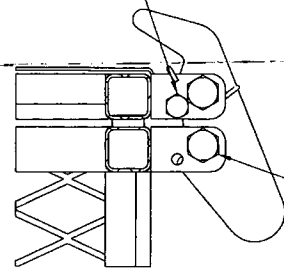
DETAIL A D8-2
D6-2

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



DETAIL B D4-2

D4032-041: AN3-16A BOLT
MS21042L3 NUT
D4032-043: AN3-20A BOLT
MS21042L3 NUT

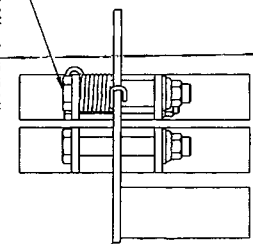


SECTION C-C B5-2
B7-2

D4032-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

D4032-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

AN5-17A BOLT
NAS1149F0563P WASHER
MS21042L5 NUT



D2530 WELDMENT
REF

VIEW F-F C3-3

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET

AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-2

D3953-17 GAS SPRING SPACER

D3953-19 GAS SPRING BRACKET

AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION E-E B1-2

RELEASED
10-08-17-9

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DESIGN	AUS	DART AEROSPACE LTD	
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. D
MFG. APPR.	J.F.S. P.J.M.	D4032	SHEET 3 OF 3
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	SHORT BASKET ASSY (350) NTS	
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